

Work Order ID 64274

December 1, 2010 12:26:30 PM



Page 1

Item ID: D350-600-249

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacepod Upgrade

Start Date: 12/01/10 Start Qty: 2.00

Required Date: 12/03/10 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

N/A

Rev C

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP 350-600-249 CHG001

8/10/12/03

OK per BG 10/12/01

110

0.00



Packaging

Packaging

Memo

0.00

Packaging

Packaging

10/12/03

SP(40)

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/10/12/03

(74)

Work Order ID 64274

December 1, 2010 12:26:30 PM



Page 2

Item ID: D350-600-249

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacepod Upgrade

Start Date: 12/01/10 Start Qty: 2.00



Cust Item ID:

Required Date: 12/03/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350/600-
249; Location: _____, PPP Rev: A

10/12/03 *(9)*

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 10/12/03
MF
10-12-03

Picklist Print

December 1, 2010 12:26:06 PM

Page 1

Work Order ID: 64274

Parent Item: D350-600-249

Parent Item Name: Spacepod Upgrade



Start Date: 12/01/10

Required Date: 12/03/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A new issue 07.01.31 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

A3235-020-935~ Purchased No



Washer - Countersunk

Location

Loc Qty

Loc Code

ST281

468

106150

468

120

Each

245.0000

10

20

AN526C832R10

Purchased

No



Screw

Location

Loc Qty

Loc Code

ST327

245

104603

3

113154

92

114382

50

115101

100

120

Each

620.0000

6

12

AN526C832R14

Purchased

No



Screw

Location

Loc Qty

Loc Code

ST327

620

104916

620

Picklist Print

December 1, 2010 12:26:06 PM

Work Order ID: 64274

Parent Item: D350-600-249

Parent Item Name: Spacepod Upgrade

Page 2

8

AN526C832R24

Purchased

No

110

Each

68.0000

Start Date: 12/01/10

Start Qty: 2.00

Required Date: 12/03/10

Required Qty: 2.00

Screw

Location

Loc Qty

Loc Code

ST325

20

115518

20

ST327

48

110179

48

AN5-5A

Purchased

No

120

Each

90.0000

Bolt

Location

Loc Qty

Loc Code

ST337

90

110865

90

AN960JD10

NAS1149D0363J

Purchased

No

120

Each

8.0000

Washer

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

2

105792

2

AN960JD10L

NAS1149D0332J

Purchased

No

120

Each

0.0000

Washer

December 1, 2010 12:26:06 PM

Shop Packet Print

Page 2

Picklist Print

December 1, 2010 12:26:07 PM

Work Order ID: 64274

Parent Item: D350-600-249

Parent Item Name: Spacepod Upgrade

Page 3

8

AN960JD516 NAS1149D0563J Purchased

No

120

Each

34.0000

4

8

Start Date: 12/01/10

Required Date: 12/03/10

Start Qty: 2.00

Required Qty: 2.00



Washer

Location

Loc Qty

Loc Code

ST

34

103694

18

107534

12

109287

4

AN960JD8 NAS1149DN832 Purchased

No

120

Each

10.0000



Washer

Location

Loc Qty

Loc Code

ST347

10

105059

10

D2228 Manufactured

No

120

Each

28.0000



Bracket Plate

Location

Loc Qty

Loc Code

ST009

28

48228

28

D2237 Manufactured

No

120

Each

42.0000



Striker Plate

Location

Loc Qty

Loc Code

ST010

42

62212

42

Start Date: 12/01/10 Required Date: 12/03/10
Start Qty: 2.00 Required Qty: 2.00
AN960JD516 34.0000 4 8
AN960JD8 10.0000 10
10/12/3 SP M115300 M115996 M114742

AN960JD8 10.0000 10
10/12/3 SP M115300 M115996 SP
M11602 10/12/3 SP
45x

D2228 28.0000 2
10/12/3 SP

D2237 42.0000 2
10/12/3 SP 4x

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-600-249 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>64274</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/12/03	#100	Wrong qty for AN460SDS should be 24 per kit		→ correct Bom. ADD copy to who for Recd.				
		R.C. Bom not correctly updates to IIIN Part B list		→ ADD missing amount + kits	lc 14/12/3	S 10/12/03		S 10/12/03

NOTE: Date & initial all entries

Picklist Print

December 1, 2010 12:26:08 PM

Work Order ID: 64274

Parent Item: D350-600-249

Parent Item Name: Spacepod Upgrade

Page 4
8

D2464



3/4 Seal

S 4 (D2464-0360)
Cut (1) of 36 per kit
L7 measure
8/12/13

Manufactured No

120 f

623.6334 3

6.315789

Start Date: 12/01/10

Required Date: 12/03/10

Start Qty: 2.00

Required Qty: 2.00

Location

Loc Qty

Loc Code

ST402

123.6334

48173

123.6334

ST404

500

61878

500

Manufactured No

120 Each

55.0000

2

4

Location

Loc Qty

Loc Code

ST033

55

43758

26

56701

3

60287

26

Manufactured No

120 Each

24.0000

2

4

D3538-1



Hinge Bracket

Location

Loc Qty

Loc Code

ST069

24

56531

12

59141

12

Manufactured No

120 Each

17.0000

1

2

D3547-1



Bracket

Location

Loc Qty

Loc Code

ST069

17

50260

3

57951

14

December 1, 2010 12:26:08 PM

Shop Packet Print

Page 4

Picklist Print

December 1, 2010 12:26:08 PM

Work Order ID: 64274

Parent Item: D350-600-249

Parent Item Name: Spacepod Upgrade

Page 5

4

Start Date: 12/01/10

Required Date: 12/03/10

Start Qty: 2.00

Required Qty: 2.00

Sep
D3550-1
Strut

Manufactured No 120 Each 14.0000

1 2 10/12/35

Location Loc Qty Loc Code

ST271 14
48367 4
56332 10

4

S
H
D3552-7
Door Prop

Manufactured No 120 Each 9.0000

1 2 10/12/35

Location Loc Qty Loc Code

ST272 9
52451 9

4

S
D3554-7
Ball Stud

Manufactured No 120 Each 23.0000

1 2 10/12/35

Location Loc Qty Loc Code

ST070 23
37674 23

4

S
D3557-1
Bracket

Manufactured No 120 Each 10.0000

1 2 10/12/35 (4x)

Location Loc Qty Loc Code

ST070 10
50283 10

4

December 1, 2010 12:26:08 PM

Shop Packet Print

Page 5

Picklist Print

December 1, 2010 12:26:09 PM

Work Order ID: 64274

Parent Item: D350-600-249

Parent Item Name: Spacepod Upgrade

Page 6

1/8

MS20426AD4-5

Purchased

No

120

Each

5,731.000

2

4

Start Date: 12/01/10

Required Date: 12/03/10

Start Qty: 2.00

Required Qty: 2.00



Rivet

Location

Loc Qty

Loc Code

ST317

5731

6733

749

6874

4982

120

Each

600.0000

MS21042L08

Purchased

No

Nut

Location

Loc Qty

Loc Code

ST300

600

115835

100

116082

100

116188

400

120

Each

1,361.000

2

4

MS21042L3

Purchased

No

Nut

Location

Loc Qty

Loc Code

ST300

1361

114784

365

115835

996

December 1, 2010 12:26:09 PM

Shop Packet Print

Page 6

Picklist Print

December 1, 2010 12:26:09 PM

Work Order ID: 64274

Parent Item: D350-600-249

Parent Item Name: Spacepod Upgrade

Page 7
1/8

MS21042L5-

Purchased

No

120

Each

1,309.000

Start Date: 12/01/10

Required Date: 12/03/10

Start Qty: 2.00

Required Qty: 2.00

Nut

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

1283

115156

83

115594

500

116104

200

116105

500

MS24694-S69

Purchased

No

120

Each

95.0000

Screw

Location

Loc Qty

Loc Code

ST289A

95

112492

95

MS27039-08-11

Purchased

No

120

Each

37.0000

Screw

Location

Loc Qty

Loc Code

ST288

37

114382

37

MS27039-1-25

Purchased

No

120

Each

74.0000

Screw

Location

Loc Qty

Loc Code

ST292

74

102602

73

17570

1

December 1, 2010 12:26:09 PM

Shop Packet Print

Page 7

Picklist Print

December 1, 2010 12:26:10 PM

Work Order ID: 64274

Parent Item: D350-600-249

Parent Item Name: Spacepod Upgrade

Page 8

8



Start Date: 12/01/10

Required Date: 12/03/10

Start Qty: 2.00

Required Qty: 2.00

NAS1515H3

Purchased

No

120

Each

174.0000

2



12/12/13

sl

(8)

Washer

Location

Loc Qty

Loc Code

ST277

174

111268

4

115675

70

115935

100

8

-241	-242	-243	-245	-246	-247	-248	-249	-449	Part Number	Description
X									D350-600-241	SPACEPOD™ LH, AS350
	X								D350-600-242	SPACEPOD™ RH, AS350/355
		X							D355-600-243	SPACEPOD™ LH, AS355
1		1	X						D350-600-245	DOOR ASSEMBLY LH
	1			X					D350-600-246	DOOR ASSEMBLY RH
					X				D350-600-247	SPACEPOD™ UPGRADE KIT LH
						X			D350-600-248	SPACEPOD™ UPGRADE KIT RH
							X		D350-600-249	SPACEPOD™ UPGRADE KIT
1	1	1						X	D350-600-449	SWITCH RELOCATION KIT
2	2	2							D2174-041	WEB ASSEMBLY
							1		D2464-0360	NEOPRENE SEAL
			1	1					D2589	KEYS, KEY CHAIN
1	1	1							D2985	DECAL
1	1	1			1	1	1		D3015-3	LOCK NUT
			1		1				D3186-3	SPACEPOD DOOR, LH
				1		1			D3186-4	SPACEPOD DOOR, RH
1**		1**							D3187-1	FLOOR
	1**								D3187-2	FLOOR
1									D3188-5	SPACEPOD BODY
	1								D3188-6	SPACEPOD BODY
		1							D3188-7	SPACEPOD BODY
1	1	1			1	1	1		D3547-1	BRACKET
1	1	1			1	1	1		D3550-1	STRUT
			1	1	1	1	1		D3552-7	GAS SPRING
1	1	1			1	1	1		D3554-7	BALL STUD
8	8	8							AN3-3A	BOLT
2	2	2							AN3-10A	BOLT
8	8	8							AN3H4	BOLT
1	1	1			1	1	1		AN5-5A	BOLT
36	36	36							AN525-10R7	SCREW
8	8	8			4	4	4		AN526C832R14	SCREW
7	7	7							MS24694S67	SCREW
1	1	1			1	1	1		MS24694S69	SCREW
			2	2	2	2	2		MS27039-0811	SCREW
8	8	8			1	1	1		AN3235-020-935	WASHER
8	8	8							AN960JD10	WASHER
16	16	16			1	1	1		AN960JD10L	WASHER
			4	4	8	8	8		AN960JD8	WASHER
3	3	3			3	3	3		AN960JD516	WASHER
			2	2	2	2	2		NAS1515H3	NYLON WASHER
			2	2	6	6	6		MS21042L08	NUT
16	16	16			1	1	1		MS21042L3	NUT (or MS21042-3)
1	1	1			1	1	1		MS21042L5	NUT
16	16	16							AKS7-1032-130	INSERT
28**	28**	28**							AKS7-1032-130	INSERT
								3	M81824/1-2	SPLICE

• COPYRIGHT © 2006 BY DART AEROSPACE LTD •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: E

Date: 09.07.31

-241	-242	-243	-245	-246	-247	-248	-249	-449	Part Number	Description
								2	D3597-1	FEMALE SPADE CONNECTOR
								1	D3598-2-096	EXPANDABLE SLEEVE
								24	D3599-1	TIE-WRAP
								24	D3600-1	TIE-WRAP MOUNT
								24 FT	M22759/16-22-9	WIRE
			1*	1*	1*	1*			D2464-1250	NEOPRENE SEAL
1**		1**	1*		1*				D3567-1	DECAL
	1**			1*		1*			D3567-2	DECAL
			2*	2*					D2586	LATCH
			2*	2*					D2585	MOUNTING CHANNEL
			2*	2*					D2621	LATCH PLATE
			2*	2*					MS27039-1-15	SCREW
					2	2	1		MS27039-1-25	SCREW
			2*	2*	2	2	1		AN960JD10	WASHER
			2*	2*	2	2	1		MS21042L3	NUT (or MS21042-3)
			1*	1*					D2857-1	HINGE BRACKET
			1*	1*					D2857-2	HINGE BRACKET
			2*	2*					D2228	BACKING PLATE
			8*	8*	8	8	8		AN526C832R10	SCREW
			8*	8*	8	8	8		AN960JD8	WASHER
			8*	8*	8	8	8		MS21042L08	NUT
			1*	1*	1*	1*	1		D3557-1	BRACKET
			2*	2*	2*	2*	2		D2228	BACKING PLATE
			1*	1*	1*	1*	1		D3554-7	BALL STUD
			1*	1*	1*	1*	1		AN960JD516	WASHER
			1*	1*	1*	1*	1		D3015-3	LOCK NUT
			2*	2*	2*	2*	2		AN526C832R14	SCREW
			2*	2*	2*	2*	2		AN526C832R10	SCREW
			4*	4*	4*	4*	4		AN960JD8	WASHER
			4*	4*	4*	4*	4		MS21042L08	NUT
2**	2**	2**			1	1	1		D2237	STRIKER PLATE
4**	4**	4**			2	2	2		MS20426AD4-5	RIVET
2**	2**	2**			2	2	2		D3538-1	HINGE BRACKET
2**	2**	2**							D2179	HINGE BRACKET PLATE
4**	4**	4**			4	4	4		AN526C832R24	SCREW
4**	4**	4**			4	4	4		AN960JD8	WASHER
4**	4**	4**			4	4	4		MS21042L08	NUT

* PRE-INSTALLED ON D3186-3/-4 SPACEPOD™ DOOR

** PRE-INSTALLED ON D3188-5/-6/-7 SPACEPOD™

• COPYRIGHT © 2006 BY DART AEROSPACE LTD •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: E

Date: 09.07.31

Work Order ID 64274

December 1, 2010 12:26:30 PM



Page 1

Item ID: D350-600-249

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacepod Upgrade

Start Date: 12/01/10 Start Qty: 2.00



Cust Item ID:

Required Date: 12/03/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *V*

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

N/A

Rev C

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP 350-600-249 CHG001

110

0.00



Packaging

Packaging

Memo

0.00

Packaging

Packaging

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

PS 10-12-1
(2) + (2)